

Date: Wednesday, 16/07/2008 8:55:54 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARSHOE
<b>Job Number</b> :	40552		
<b>Estimate Number</b> :	13315		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37933
<b>This Issue</b> :	16/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3793 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39812	<b>Drawing Revision</b> :	A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JLD 08.7.14	<b>Due Date</b> :	04/08/2008
<b>Comment</b> :	Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC		

Qty: 24 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
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**Comment:** Qty.: 1.3469 sf(s)/Unit Total : 32.3266 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 108 724 IB 8-8-5

2.0	WATER JET	FLOW WATER JET
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PD →

**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3793  
 Dwg Rev: A IB 8-8-5  
 Prog Rev: A

24

2-Deburr if necessary IB 8-8-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

8/8/15

224

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

24 08/08/07 24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3793-3 PAR #: N/A Fault Category: Prod / FAB. ASS <sup>mod to Smith</sup> NCR: (Yes) No DQA: D Date: 08/08/08  
 QA: N/C Closed: A Date: 08/08/08

NCR: <u>40552</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/8/5</u>	<u>1</u>	two parts scrap holes <del>are</del> and brands <del>are</del> too large. .531 x 0.750 is 0.550 x .791 and 0.360 x 0.300 are 0.315 x 0.320.	<u>[Signature]</u>	Scrap and destroy and Replace Qty <u>(x2)</u> <u>B&amp; M 108 724</u>	<u>[Signature]</u> <u>8-8-5</u>	<u>[Signature]</u> <u>8/8/5</u>	<u>[Signature]</u> <u>08/12</u>	<u>[Signature]</u> <u>8/8/5</u>
		R.C. Set up set						

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 8:55:54 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 40552

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/09 +20

7.0

POWDER COATING

POWDER COATING



M106442



(24x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:10  
320 °F  
2:40

M-1 08/08/07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-07

(220)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

08-08-07

(224)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/08

Job Completion



MF 08-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40552
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

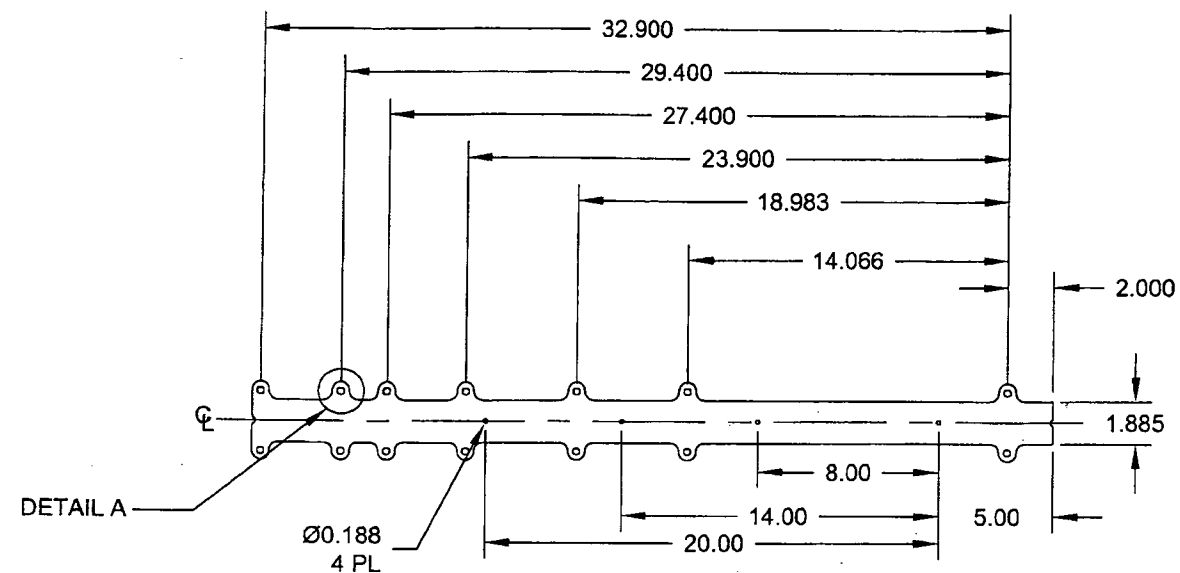
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	✓			
0.300 x 0.300	+/-0.010	.309 x .309	✗			
1.885	+/-0.010	1.894	✗			
4.389	+/-0.010	4.385	✗			
6.547	+/-0.010	6.541	✗			
6.00	+/-0.030	6.00	✗			
6.75	+/-0.030	6.75	✗			
2.000	+/-0.010	2.000	✗			
4.750	+/-0.010	4.747	✗			
9.500	+/-0.010	9.500	+			
14.250	+/-0.010	14.250	✗			
17.750	+/-0.010	17.750	✗			
26.735	+/-0.010	26.735	+			
Ø0.531 x 0.780	+0.008/-0.001	.531 x .783	✗			

Measured by: RB
Date: 8-8-5

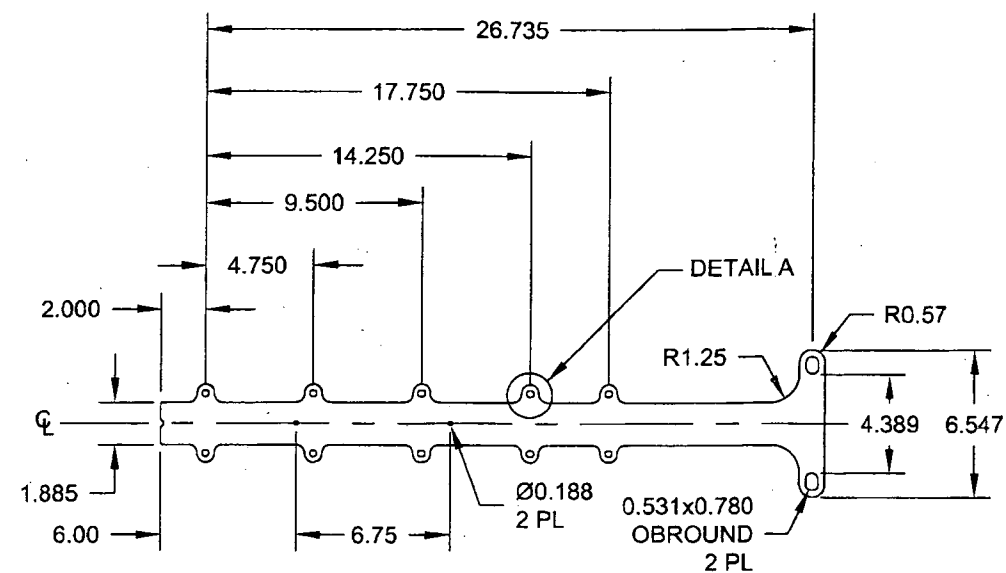
Audited by: S
Date: 8/8/5

Prototype Approval:	N/A
Date:	N/A

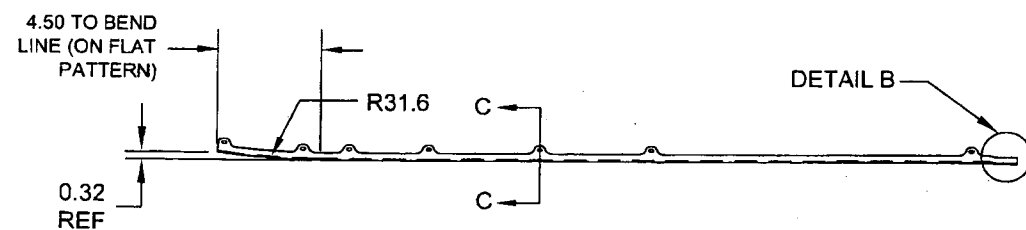
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	



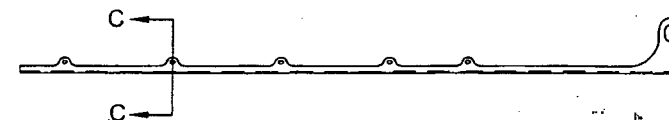
**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**NOTES:**

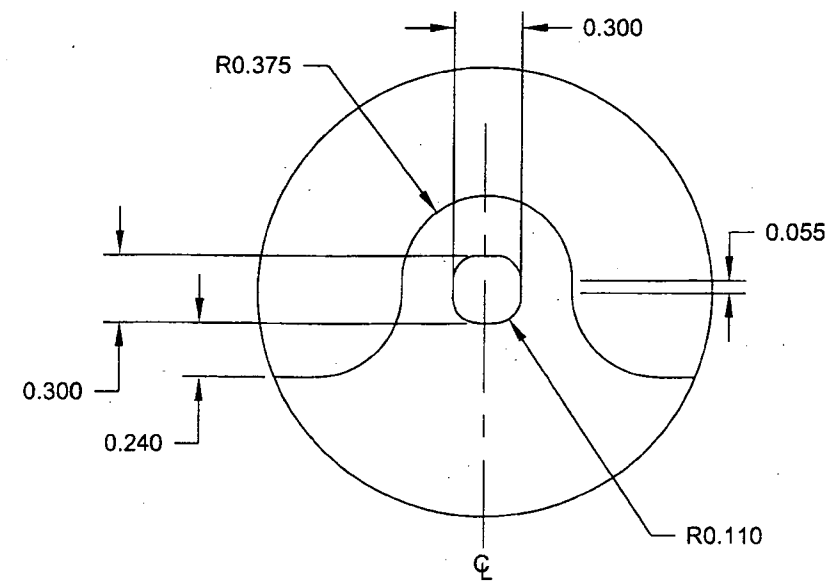
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

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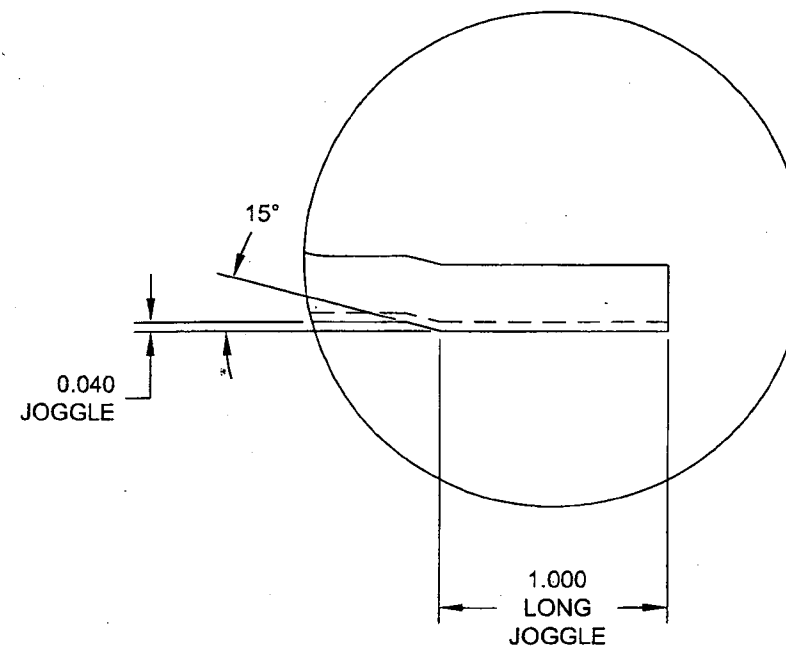
A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

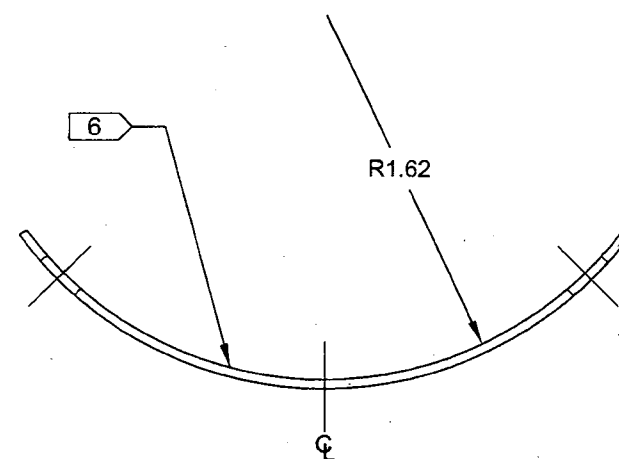
D  
C  
B  
A



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

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8 7 6 5 4 3 2 1